

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012345**Date Inspected:** 27-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 12BE, weld No.SEG3002*-008. The welder is identified as #044771. ZPMC QC is identified as Mr. Guo Xing Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 2G position for the OBG Traveler Rail , weld No.10TR3-037. The welder is identified as #206623. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-REPAIR.The weld repair report is identified as B-CWR-1086.

SMAW in the 4G position for the OBG Segment 11DW, weld No.SEG071A-009. The welder is identified as #047864. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW in the 3G position for the OBG Segment 11DW, weld No.SEG071B-042. The welder is identified as #201215. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with

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WPS-B-T-2233-Tc-U4b-F.

During Quality Assurance random in-process observations of the fabrication of segment 12AW and 12BW, this Quality Assurance Inspector (QA) discovered that the ZPMC personnel have performed Free Hand Flame Cutting more than 300mm in length. The details are given below.

The approximate cut length for the Floor Beam FB3072 plate number X3166D measured 1025mm from Bottom plate on Panel point PP111.5 at Counter Weight Side.

The approximate cut length for the Floor Beam FB3079 plate number X3207M measured 4700 mm from Bottom plate on Panel point PP111.5 at Counter Weight Side.

The approximate cut length for the Floor Beam FB3064 plate number X33267B (SPCM) measured 1500 mm from Bottom plate on Panel point PP112 at Counter Weight Side.

The approximate cut length for the Floor Beam FB3080 plate number X3183D (SPCM) measured 4700 mm from Bottom plate on Panel point PP112 at Counter Weight Side.

The approximate cut length for the Floor Beam FB3070 plate number X3166A measured 1025mm from Bottom plate on Panel point PP112.5 at Counter Weight Side and 1025 mm from Bottom plate at Cross Beam Side.

The approximate cut length for the Floor Beam FB3083 plate number X3207A measured 2000 mm from Bottom plate on Panel point PP112.5 at Cross Beam Side.

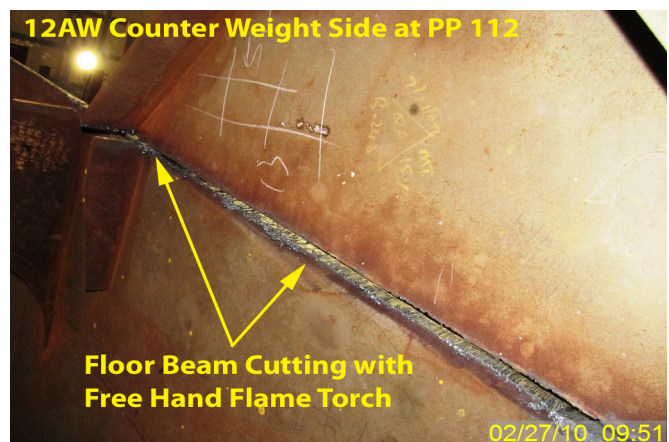
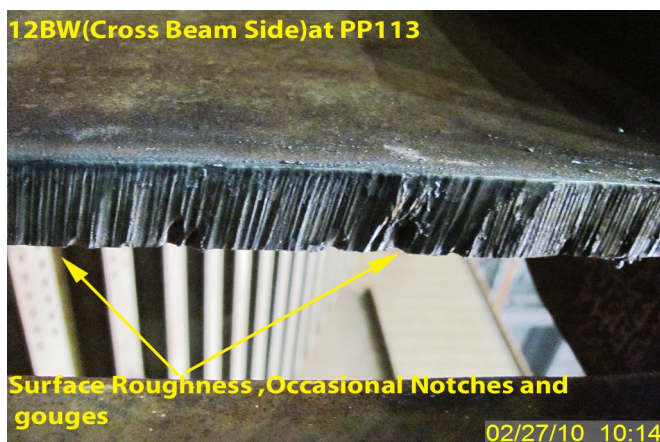
The approximate cut length for the Floor Beam FB3066 plate number X3267E measured 1500 mm from Bottom plate on Panel point PP113 at Cross Beam Side.

The approximate cut length for the Floor Beam FB3085 plate number X3181D measured 2000 mm from Bottom plate on Panel point PP113 at Cross Beam Side.

OBG Segment 12AW and 12BW are currently located inside of bay 14.

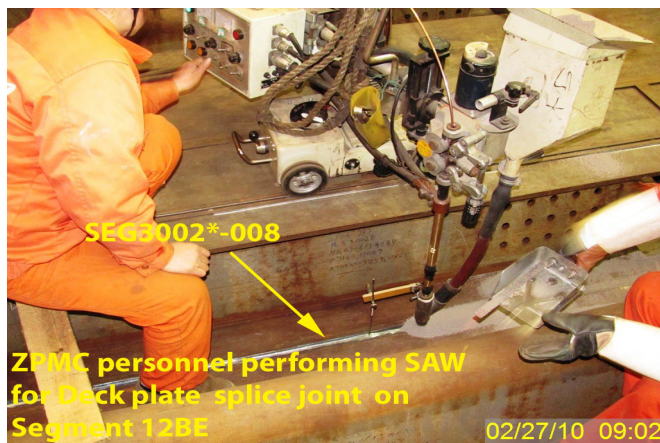
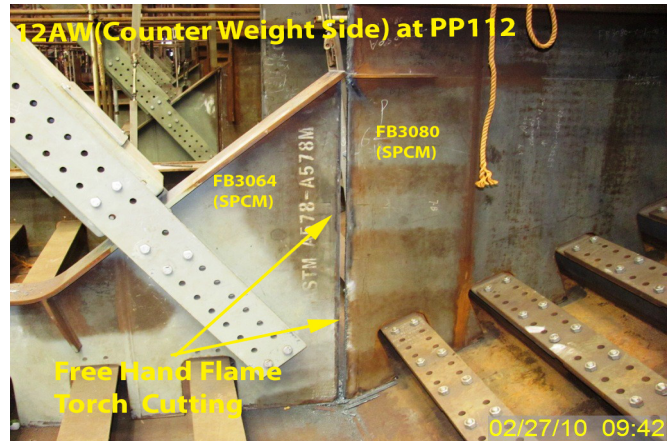
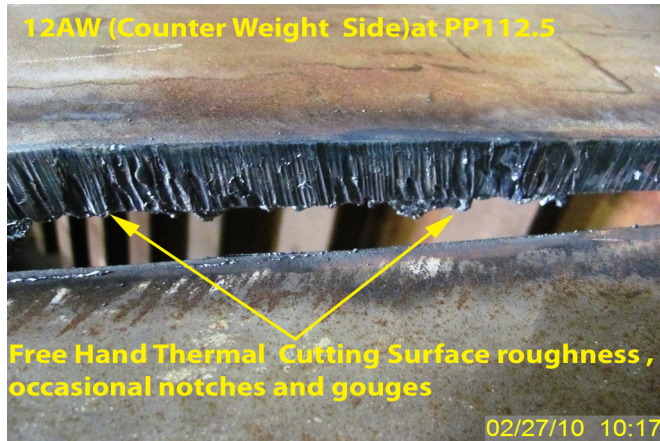
This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Reviewed By: Patterson,Rodney

Quality Assurance Inspector

QA Reviewer
